

Work Order ID 147214

June 07, 2016 1:18:03 PM

147214

11/21
~~Ship June 20~~
 Easy

Page 1

Item ID: D412-776-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Glareshield
 Start Date: 6/10/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/14/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SK Date: 6/7/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-776	Rev B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-776-011		CHG001						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS 27 9-89
 NOV 23 2016
 DAS 28 9-89
 DAS 6 9-89
 NOV 08 2016

NOV 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Work Order ID 147214

June 07, 2016 1:18:03 PM

147214

Page 2

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Revision ID: Stop ***NS2***
Item Name: Glareshield
Start Date: 6/10/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/14/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					DAS 27 9-89			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-776-011 Location: _____ PPP Rev: _____								
	<i>sold</i>								
140									
140	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	Memo	0.02				DAS 21 9-89			NOV 23 2016

16-11-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER :			
Misidentified ☐	☐	Past Due ☐					

Picklist Print

June 07, 2016 1:18:15 PM

Page 1

Work Order ID: 147214

147214

Parent Item: D412-776-011

D412-776-011

Parent Item Name: Glareshield

Start Date: 6/10/2016

Required Date: 6/14/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08.05-12 new issue DD verified by: LL
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
AN3-3A Bolt		Purchased	No			120	Each	70.0000	6	6			6 9-89
AN3-3A													
** 135566x3 NOV 08 2016 135466x3 28 99													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST350				70					
				m134537				2					
				m134738				25					
				m134848				43					
AN3-5A Bolt		Purchased	No			120	Each	222.0000	10	10			6 9-89
AN3-5A													
** M135658 NOV 08 2016 28 99													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				4					
				m133686				2					
				m134055				2					
				ST350				218					
				m134502				218					
AN970-3 Washers		Purchased	No			120	Each	221.0000	4	4			28 9-89
AN970-3													
** NOV 08 2016 4													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST260a				198					
				m129630				198					
				ST321				23					
				m128057				23					

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

DAS
6
9-89

Picklist Print

June 07, 2016 1:18:15 PM

Page 2

Work Order ID: 147214

147214

Parent Item: D412-776-011

D412-776-011

Parent Item Name: Glareshield

Start Date: 6/10/2016

Required Date: 6/14/2016

Start Qty: 1.00

Required Qty: 1.00

D3690-041 Manufactured No

120 Each

0.0000

1

1

DAS 6 28 9-89

NOV 7 3 2016

D3690-041

Glareshield Assembly

D3699-041 Manufactured No

120 Each

3.0000

1

1

DAS 6 28 9-89

D3699-041

Support Assembly

Location

Loc Qty

Loc Code

ST506

3

84076

3

D3699-042 Manufactured No

120 Each

1.0000

1

1

DAS 6 28 9-89

D3699-042

Support Assembly

Location

Loc Qty

Loc Code

ST506

1

84846

1

MS20426AD3-3 Purchased No

120 Each

1,645.000

12

12

DAS 6 28 9-89

MS20426AD3-3

RIVET

Location

Loc Qty

Loc Code

GA

698

M131624

698

ST312

947

M131624

947

MS21042L06 Purchased No

120 Each

121.0000

11

11

DAS 6 28 9-89

MS21042L06

Nut

Location

Loc Qty

Loc Code

ST303

121

m134474

21

m134537

100

June 07, 2016 1:18:15 PM

Shop Packet Print

Page 2

Picklist Print

June 07, 2016 1:18:15 PM

Page 3

Work Order ID: 147214

147214

Parent Item: D412-776-011

D412-776-011

Parent Item Name: Glareshield

Start Date: 6/10/2016

Required Date: 6/14/2016

Start Qty: 1.00

Required Qty: 1.00

MS21075L08

Purchased

No

120

Each

214.0000

6

6

MS21075L08

ANCHOR NUT

**

135774

NOV 08 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST298

105

103053

55

M132035

50

ST300

109

M128635

109

DAS
27
9-89

MS35206-228

Purchased

No

120

Each

349.0000

11

11

MS35206-228

SCREW

**

NOV 08 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

80

M129682

80

ST271

269

120560

269

DAS
27
9-89

NAS1149D0332J

Purchased

No

120

Each

1,258.000

12

12

NAS1149D0332.J

Washer

**

135672

NOV 08 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

22

m134502

22

ST260a

1200

m134738

600

m134848

600

ST264

30

m134502

30

DAS
27
9-89

June 07, 2016 1:18:15 PM

Shop Packet Print

Page 3

Picklist Print

June 07, 2016 1:18:15 PM

Page 4

Work Order ID: 147214

147214

Parent Item: D412-776-011

D412-776-011

Parent Item Name: Glareshield

Start Date: 6/10/2016

Required Date: 6/14/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN616J

Purchased

No

120

Each

236.0000

11

11

NAS1149DN616.J

Washer

Location

Loc Qty

Loc Code

NOV 08 2016

ST265

236

M127726

236

DAS
27
9-89

DAS
6
9-89

DAS
28
9-89

REFERENCE ONLY**4. WEIGHT AND BALANCE**

The net weight increase associated with the D412-776-011 Replacement Glareshield Kit is negligible.

5. PARTS LIST

Qty -011	Part Number	Description
X	D412-776-011	REPLACEMENT GLARESHIELD KIT
1	D3690-041	GLARESHIELD ASSEMBLY
1	D3699-041	SUPPORT ASSEMBLY
1	D3699-042	SUPPORT ASSEMBLY
6	AN3-3A	BOLT
10	AN3-5A	BOLT
12	AN960JD10L	WASHER (or NAS1149DN332J)
11	AN960JD6L	WASHER (or NAS1149DN616J)
4	AN970-3	WASHER
12	MS20426AD3-3	RIVET
11	MS21042L06	NUT
6	MS21075L08	ANCHOR NUT
11	MS35206-228	SCREW

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Date: 08.06.24